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Production Engineering Measure on  
High Perveance Cathode-Ray Tubes

SEVENTH QUARTERLY PROGRESS REPORT

This report covers the period:  
9 December 1962 to 8 March 1963

Contract Number DA 36-039 SC-85965  
Order Number 6020-PP-61-81-81

U. S. Army Electronics Materiel Agency  
Industrial Preparedness Directorate  
Philadelphia, Pennsylvania

DDC  
JUL 15 1963  
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PICKUP TUBE OPERATION  
POWER TUBE DEPARTMENT  
**GENERAL ELECTRIC**  
Syracuse, N. Y.

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High Perveance Cathode-Ray Tubes

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Object of Study: To develop a low  
„drive (high perveance) cathode-ray  
tube incorporating electron guns of  
Focus Reflex Modulation design.

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## TABLE OF CONTENTS

	<u>Page</u>
I. Abstract . . . . .	1
II. Purpose . . . . .	2
III. Engineering Sample Tubes . . . . .	4
IV. Production Tooling . . . . .	12
V. Conclusions . . . . .	13
VI. Program for Next Interval . . . . .	14
VII. Publications and Reports . . . . .	15
VIII. Personnel . . . . .	16

## ILLUSTRATIONS

### Figure

1. Focus Reflex Modulation Gun Assembly with Spiral Focus Lens Electrode . . . . .	6
2. Test Data, Tube Type Z4808, a . . . . .	7
b . . . . .	8
3. Test Data, Tube Type Z4809, a . . . . .	9
b . . . . .	10
4. Testing Arrangement for Z4808 - Z4809 . . . . .	11

## LIST OF TABLES

Table I, Manpower Hours . . . . .	17
Focus Reflex Modulation Progress Chart . . . . .	18

I. ABSTRACT

This is the seventh quarterly report describing the progress of the production engineering measure on high perveance cathode-ray tubes for the period 9 December 1962 to 8 March 1963. During this quarter, engineering sample tubes were started, as required by the contract.

## II. PURPOSE

The Focus Reflex Modulation (FRM) principle in electron-gun design has demonstrated a capacity for low-level modulation that makes the concept useful for transistorized display equipment. The FRM development program has been based on theoretical electron-optics work and laboratory-produced models. The techniques used in the manufacture of these models have been very exacting so that correspondence between theory and measured results could be achieved. This has required precisely machined parts incorporating designs based on complex mathematical relationships.

Manufacturing methods for the current developmental models are considerably different from those used in a relatively high-volume cathode-ray tube production facility. A review of the FRM structure from the manufacturing standpoint needs to be made, particularly in terms of part shapes, stamping techniques, alignment requirements, and gun assembly techniques.

The focus reflex electron-gun designs also have to be adapted for use in military cathode-ray tube envelopes and in accordance with military specifications.

The logical steps toward providing manufacturing capability of focus reflex modulation cathode-ray tubes would be as follows:

1. Establish tube designs that would be suitable for quantity production and would meet Signal Corps specifications.

## II. PURPOSE (Continued)

2. Establish a limited manufacturing facility capable of producing two-hundred-total focus reflex modulation tubes per month on a single-shift basis. The cathode-ray tubes to be produced are divided into two representative types. The General Electric Company development tube number Z4808 has been assigned to the twelve-inch round faceplate cathode-ray tube that is to meet the requirements of Signal Corps specification SCS-105. The other type is a five-inch diameter faceplate cathode-ray tube, which has been assigned the General Electric Company development number Z4809 and which is to meet Signal Corps specification SCS-106.
3. Train unskilled or semiskilled direct labor operators to perform the process work.
4. Test the productivity and quality control with a pilot run.

A program such as this was begun with the awarding of Signal Corps Contract DA 36-039 SC-85965 to the General Electric Company. The progress of this program during the seventh three-month period is described in the following sections.

### III. ENGINEERING SAMPLE TUBES

After the conclusion of the design phase of this contract in the previous quarter, work was begun on the construction of engineering samples and preproduction tooling.

The problems encountered in the design-sample phase were limited to the spiral-lens construction. The development tubes used to prove out the lens design required oversized neck tubing to accommodate the large spiral-lens glass attached to the electron gun. The adoption of standard 1-7/16" neck tubing and the consequent reduction required in electron-gun outside diameter was the first problem area encountered.

The necessary smaller gun diameter required tooling of a mechanism that would paint the graphite spiral on the inside of the anode barrel. Prior to constructing this spiral-paint machine, several experiments were conducted, using a vacuum deposition of nichrome to form the resistive spiral. Spirals constructed in this manner were unstable in value; therefore, although this method shows promise as a high-volume production technique, more developmental work would be required.

In view of the limited time remaining on the contract, the nichrome-spiral technique was abandoned; and construction of a graphite-spiral paint machine was begun. A search for suitable graphite paints was undertaken. After some experimentation, a graphite-paint mix that would give the proper range of resistance was found. This mix could be applied easily by production workers.

### III. ENGINEERING SAMPLE TUBES (Continued)

Processing of the sample tubes was started by the first week in March. (Figure 1 shows the FRM gun assembly for these tubes.) Typical test data on these engineering samples are shown in Figure 2 (24808) and Figure 3 (24809). The testing voltage arrangement used is shown in Figure 4. Operation of the focus-electrode circuit in this manner produced a smooth focusing action with approximately one-half milli-ampere current flowing through the focus-electrode circuit. The average transconductance of the samples measured 46 micro<sup>mhos</sup>~~ms~~, as compared with 20 micro<sup>mhos</sup>~~ms~~ for a conventional cathode-ray tube.

This quarter's work has produced a uniform testing procedure for evaluating these devices and a preliminary set of production drawings.



FOCUS REFLEX MODULATION GUN ASSEMBLY  
WITH SPIRAL FOCUS LENS ELECTRODE

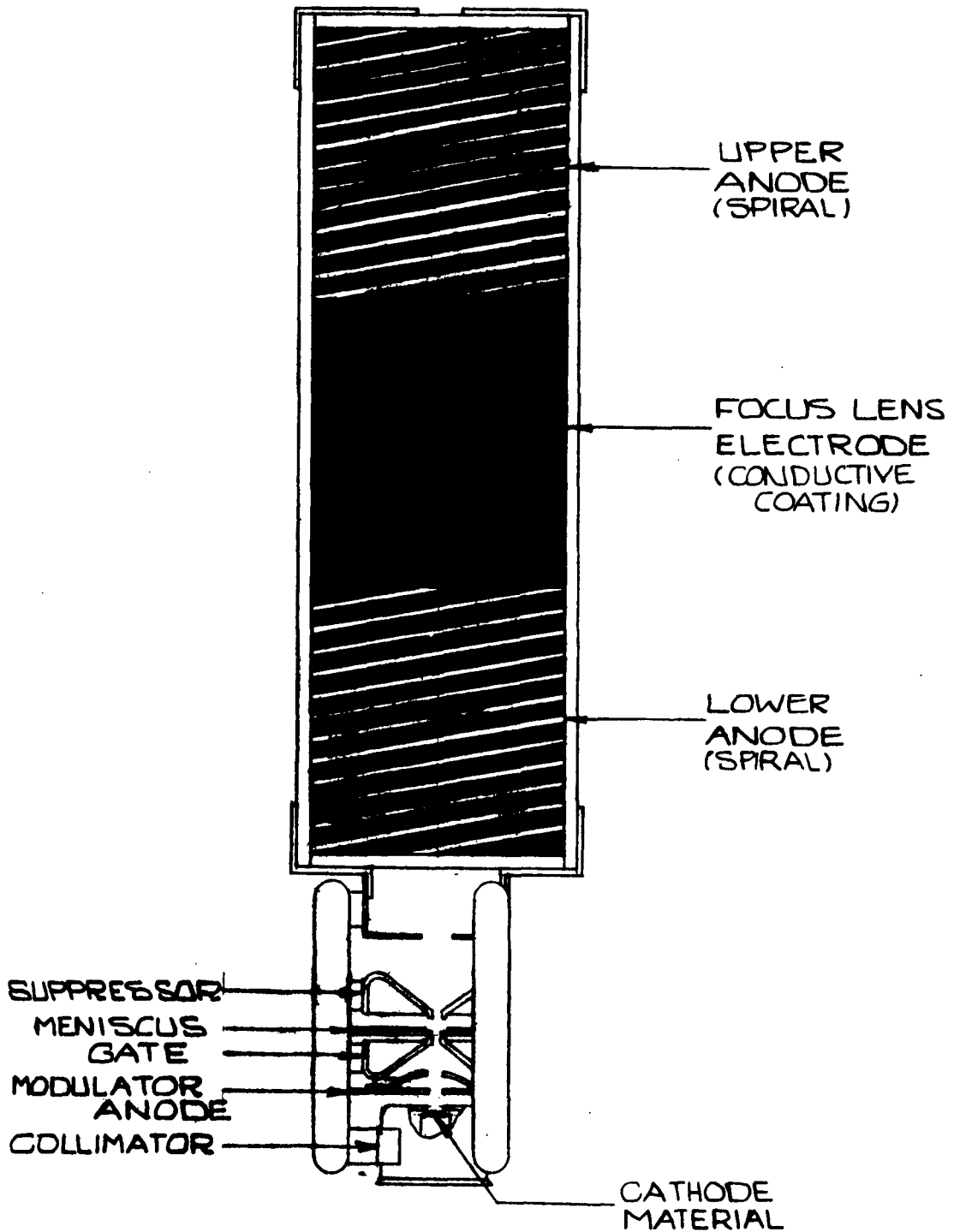


FIGURE 1

**GENERAL ELECTRIC COMPANY**

Tested By RATE

Date 26 FEB 63

Breakdown: Eb2 10 000

- 7 -

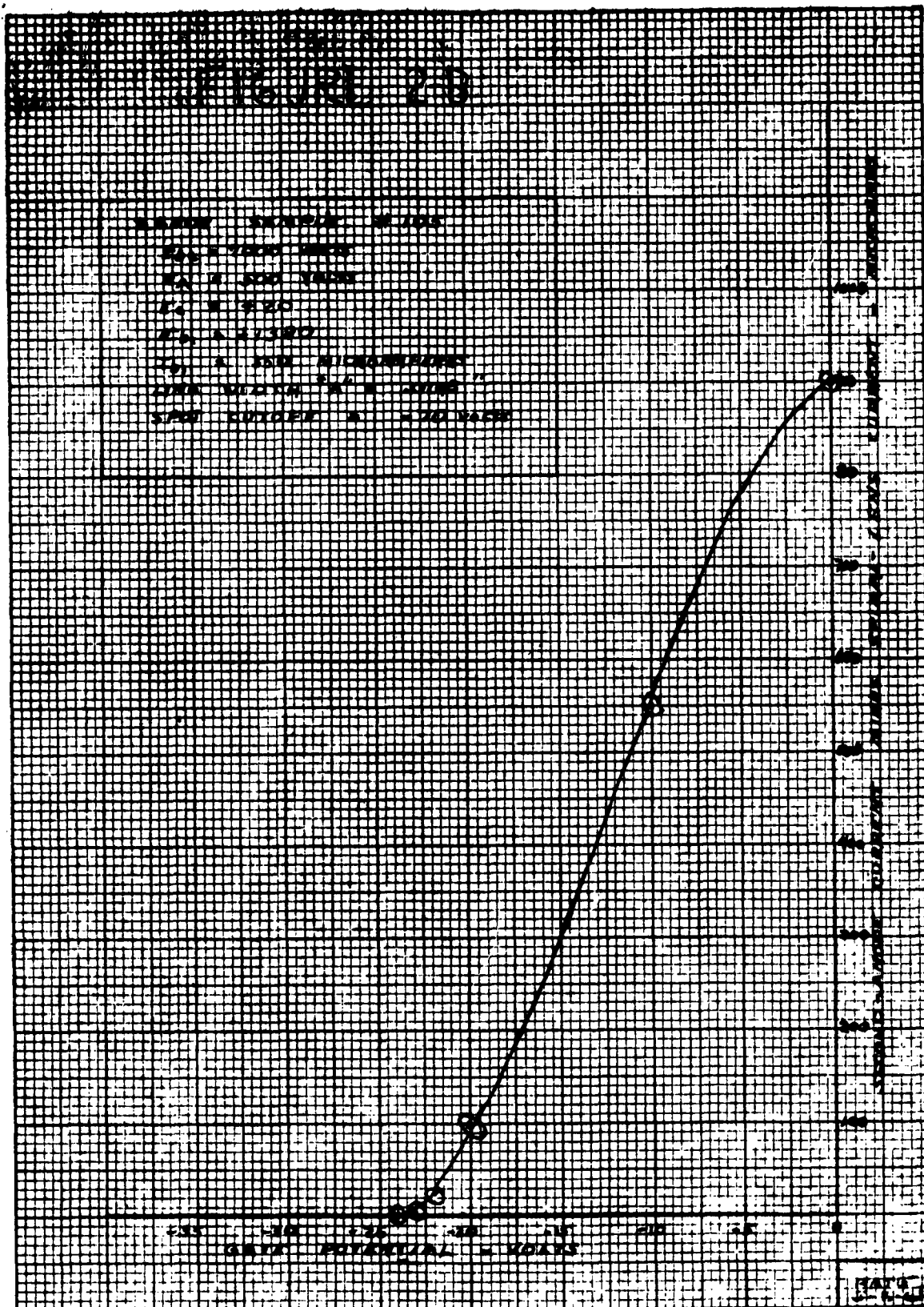


FIGURE 3-A

Focus Reflex Modulation Magnetic Deflection Tube Type 24809

Tested By RATE

**Part I: ELECTRICAL TESTS - Per Specification MIL-E-1**

Date 19 FEB 63

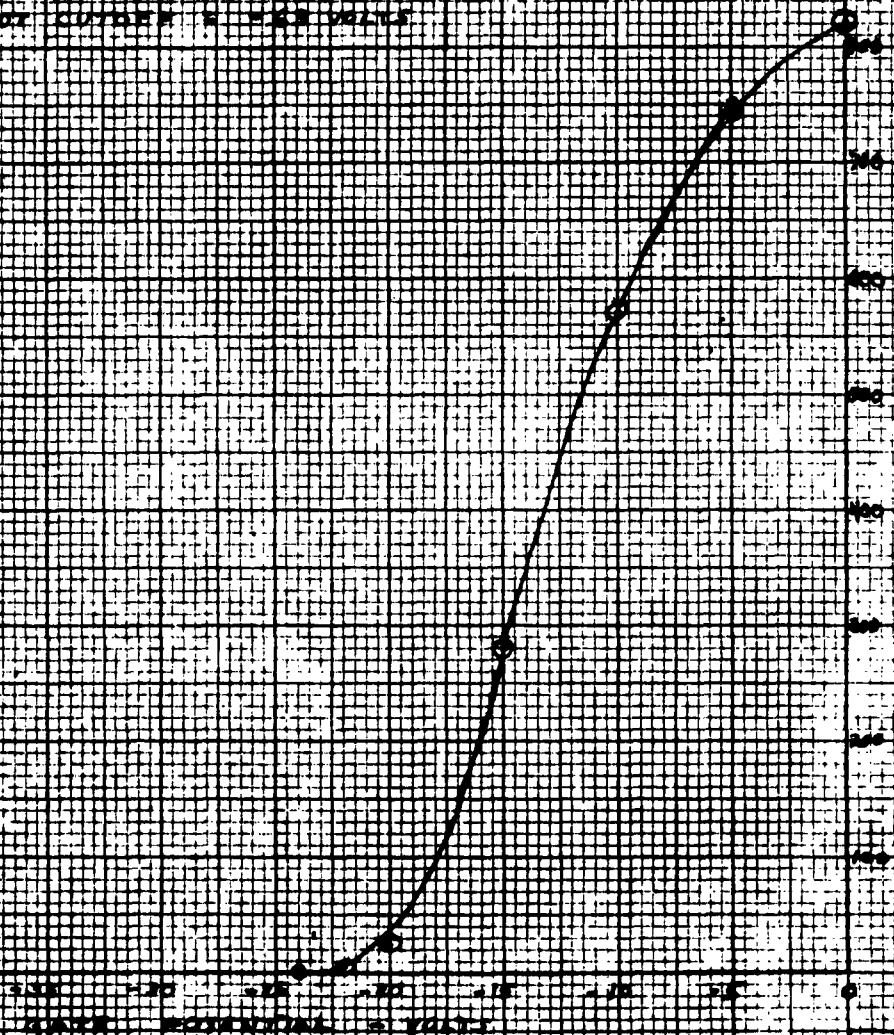
Test Conditions:  $E_f 6.3 \text{ v}$   $E_{cAOT}$   $E_{b2} 7200 \text{ v}$   $E_a 500 \text{ v}$   $E_s 455 \text{ v}$

Breakdown: Eb210000 v

Breakdown: Eb210000 V			Serial No.			
REF.	TEST	UNITS	# 101	# 102	# 103	# 104
4.6.1	Preheating		—	—	—	—
4.10.8	Heater Cur. Amps		.58	.58	.58	.58
4.12.1.1	Anode #1 Cur. $\mu$ Adc		310	260	330	300
4.12.1.2	H-K Breakdown		OK	OK	OK	OK
4.12.1.4	Voltage Bkdn.		OK	OK	OK	OK
4.12.2.2	Gas Ratio					
4.12.4.2	Stray Emis. (Std)		NONE	STRAY	NONE	NONE
4.12.5.1	Blemish		OK	OK	OK	OK
4.12.5.3	Modulation Vdc 750 $\mu$ MP		18.5	23.5	17	19
4.12.5.4	Screen(P-7) cd5		—	—	—	—
	G5:1		—	—	—	—
4.12.5.4.1	Scr. Brightness cbf		—	—	—	—
4.12.6.2	Line width A at 100 $\mu$ Adc		.0085"	.0085	.0085	.009
4.12.7.1	Spot position mm		10	12	8	10
	Zero-bias anode cur. $\mu$ Adc		990	740	820	850
	Gate Cutoff (1) $I_{b2}=5$ amp. Vdc		-28	-22.5	-22	-26.5
	Gate Raster Cutoff Vdc		-30	-32	-34	-32
	Gate Spot Cutoff Vdc		-70	-70	-63	-74
	Focus volt at 100 $\mu$ A: Vdc		1400	1400	1300	1380
4.12.4.1	Cathode Illumination		OK	OK	OK	OK
4.12.13.1	Heater-cath lkg $\mu$ Adc		0	0	0	0
	Aperture align. %		—	—	—	—
	Gate leakage: $\mu$ Adc		0	0	0	0
	COLLIMATOR: Vdc		+20	+20	+20	+20

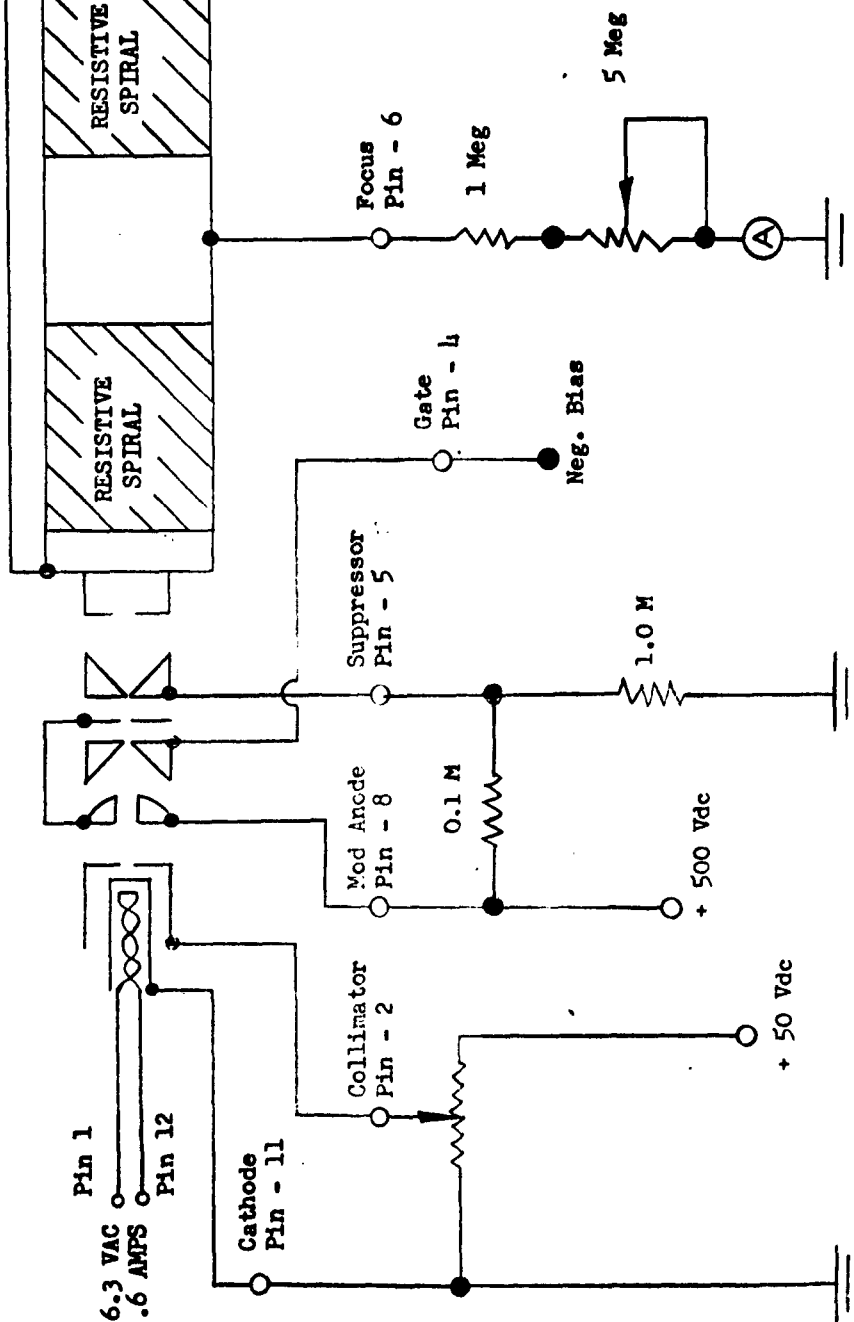
FIGURE 3-B

MEASURING SAMPLE WIRE  
 GUN NO. 2762  
 $R_A = 1000 \text{ OHMS}$   
 $R_L = 100 \text{ VOLTS}$   
 $R_D = 100 \text{ VOLTS}$   
 $R_{SL} = 1000 \text{ VOLTS}$   
 $I_{SL} = 1.50 \text{ MICROAMPS}$   
 LINEARIZATION FACTOR  $\approx 1.00$   
 SPOT CURRENT  $\approx 1.00 \text{ VOLTS}$



+7000V  
2nd Anode  
Button

TESTING ARRANGEMENT FOR 2L808 - 2L809



#### IV. PRODUCTION TOOLING

Design and construction work on the production fixtures was begun in this quarter. The required tooling consists of the electron-gun glass-beading fixture, electrode blanking and forming dies, and various positioning fixtures. These tools are designed for incorporation into existing facilities of the Pickup Tube Manufacturing Section in Syracuse. In preparation for the production run, parts are being accumulated; and preliminary processing is being performed.

The construction of the FRM guns is planned to be accomplished in three distinct steps:

1. Fabrication of the glass-beaded electrodes, as one sub-assembly.
2. Construction of the spiral lens, as the second sub-assembly.
3. Final electron-gun assembly, which will involve combining the above two sub-assemblies and adding the stemming, getters, and spring clips.

The use of the spiral Einzel lens is a radical departure from conventional electron-gun construction; but, since the electrical design is self-aligning and insensitive to resistive value deviations, manufacturing problems are not anticipated. The remainder of the tube construction will proceed along conventional lines. The target date for the completion of the preproduction sample group is May 8, 1963. Several tubes will be made prior to this date, however, to determine the suitability of the new tooling.

V. CONCLUSIONS

Several preliminary engineering samples were completed. Four Z4808 and four Z4809 Focus Reflex Modulation tubes are ready for recording of data. These tests will form the basis for the modification of the specification.



VI. PROGRAM FOR NEXT INTERVAL

As a result of the first run of engineering samples, it was determined that the specification would require some modification. This modification will be reviewed and defined during the coming quarter.

VII. PUBLICATIONS AND REPORTS

Monthly Status Report #19 - Edward T. Rate

Monthly Status Report #20 - Edward T. Rate

Monthly Status Report #21 - Edward T. Rate

#### VIII. PERSONNEL

The Manpower Hours Table on page       shows the estimated and actual hours worked during the seventh-quarter period. Laboratory personnel time required to process the experimental tubes is included under the working leader heading. Mr. D. Botsford is performing the production tooling design and construction phase of the program.

TABLE I

MANPOWER HOURSESTIMATED AND ACTUAL

<u>Contributor</u>	<u>Seventh Quarter</u>		<u>Grand Total</u>	
	<u>Estimated</u>	<u>Actual</u>	<u>Estimated</u>	<u>Actual</u>
E. T. Rate	60	105	660	877
Dr. K. Schlesinger and Assistant	0	5	80	164
W. J. Noroski	10	0	170	0
D. Botsford	30	0	210	0
Drafting	20	43	165	96
Working Leader including Laboratory	160	167	670	1095
Machine Shop	0	120	420	556.5
Factory	550	0	600	0
Test Equipment	0	0	240	16
	830	440	3215	2804.5

**FOCUS REFLEX MODULATION PROGRESS CHART**

Phases	Quarter		1		2		3		4		5		6		7		8									
	Month		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24
1. REPORTS a. Monthly b. Quarterly c. Final																										
2. TUBE DESIGN a. Z-4808 Design b. Z-4809 Design																										
3. FACILITY a. Specification and Design b. Procurement and Preparation																										
4. PERSONNEL TRAINING a. Leader b. Direct Labor Operators																										
5. PRODUCTION a. Engineering Samples b. Pilot Run of 200 Tubes c. Preproduction Samples																										

Proposed  Actual 

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